

Work Order ID 85704

June-13-12 4:06:07 PM

85704

Page 1

Item ID: D3307-041
Revision ID:
Item Name: Access Panel Assembly

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 13/06/2012 Start Qty: 6.00
Required Date: 27/06/2012 Req'd Qty: 6.00

6

6

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/14
QC: Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3307	Rev <u>#3</u>

100	FLOW WATER JET	0.00
-----	----------------	------

100

Waterjet

FLOW CNC Waterjet

304 .032

Memo

1-Cut D3307-1 as per Dwg D3307 Dwg Rev: R Prog
Rev: B 2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00
-----	---	------

110

QC

Quality Control

Memo

120	QC8- Inspect parts - second check	0.00
-----	-----------------------------------	------

120

QC

Quality Control

Memo

0.00 806816
0.00

B12-6-17

B12-6-17

806816

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

130

NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

bend as per dwg D3307

6

0

FF
12-06-19

140

140

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-Bond gasket as per dwg D3307

6

FF
12-07-06

150

150

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

5/21/06

/ (C) DD 12-07-06

Dart Aerospace Ltd

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 233 A

0.00

160

Packaging

Memo

0.00

Packaging

(6)

12/7/10

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

CK

12/7/11

MF

12-07-10

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Picklist Print

June-13-12 4:06:10 PM

Page 1

Work Order ID: 85704

85704

Parent Item: D3307-041

D3307-041

Parent Item Name: Access Panel Assembly

Start Date: 13/06/2012

Required Date: 27/06/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: A08.08.05New issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3307-3		Manufactured	No			100	Each	8.0000	1	6			

D3307-3

Gasket

**

⑥ 85704-12-07-06

Location

Loc Qty

Loc Code

ST233A

86093

8

44725

1

80171

7

M304S22GA

Purchased

No

140

sf

239.9900

0.26

1.56

**

85704-12-06-17

M304S22GA

304/316 .032 Sheet

Location

Loc Qty

Loc Code

- MAT020

239.99

118271

8.88

120866

77.36

121889

153.75

120866

⑥

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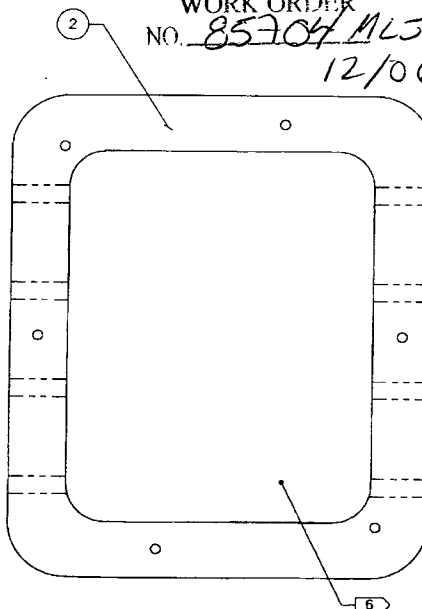
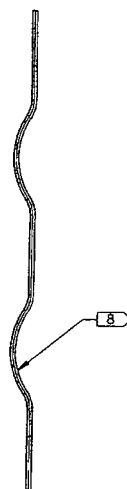
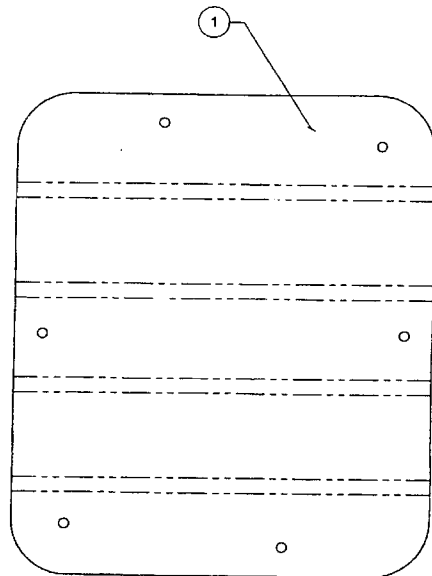
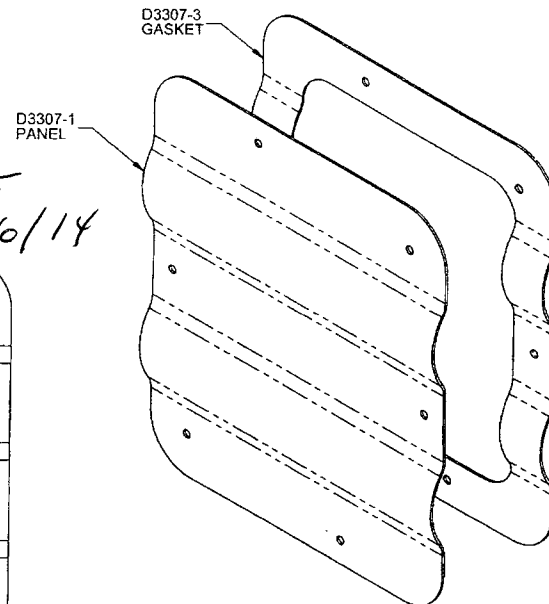
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ITEM	QTY	P/N	DESCRIPTION
	X	D3307-041	ACCESS PANEL ASSY
1	1	D3307-1	PANEL
2	1	D3307-3	GASKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85704 ML5
12/06/14



D3307-041 ACCESS PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3307-041" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
- 7) WEIGHT: 0.37 lbs
- 8) INSTALL GASKET ON THIS SIDE USING 3M SCOTCH-GRIP ADHESIVE P/N 1300/1300L IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS

RELEASED
2012-05-07
MD

B	- MOVE TWO DIAGONAL CORNER HOLES TO ELIMINATE INTERFERENCE AT INSTALLATION POINT - CORRECTED FLAT PATTERN OVERALL LENGTH (C4-3) - REF: PAR 12-165	RP	12.04.11
A	NEW ISSUE	RF	04.09.23
REV	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RP		
CHECKED	AP		
MFG. APPR.	AP		
APPROVED	AP		
DE APPR.	AP		
DATE	12.04.11		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3307 SHEET 1 OF 4 TITLE ACCESS PANEL ASSY SCALE .NTS <small>COPYRIGHT © 2004 BY DART AEROSPACE LTD This document is the property of DART AEROSPACE LTD and is supplied on the express condition that it is not to be used for any purpose or copied or otherwise reproduced without written permission from DART AEROSPACE LTD.</small>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

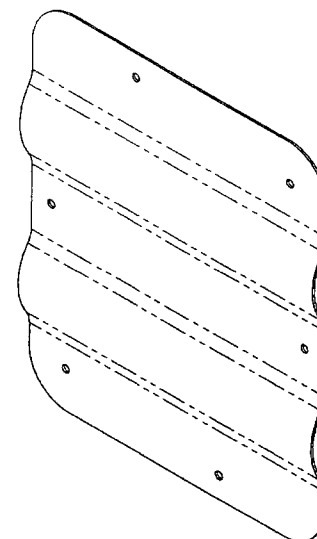
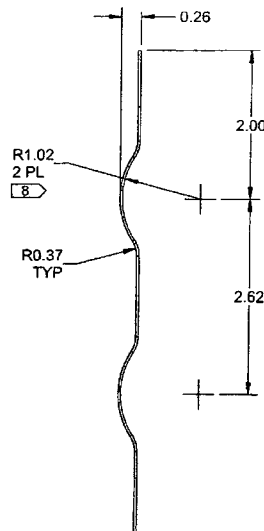
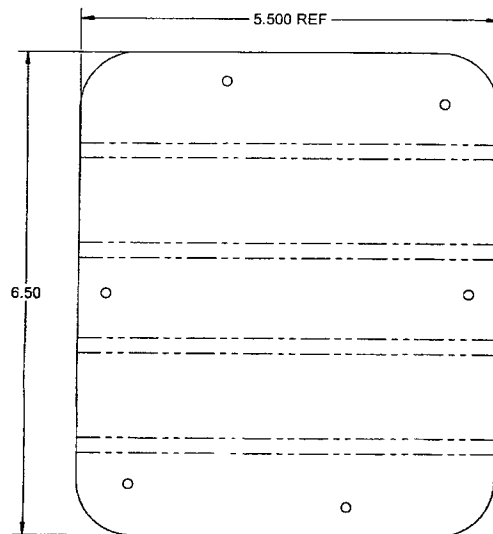
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

85704



D3307-1 PANEL

RELEASED
2012-05-07

NOTES:

- 1) MATERIAL: MAKE FROM D3307-1F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs
- 8) FORM USING DT8745

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	RP	DRAWING NO.	REV. B
MFG. APPR.		D3307	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL ASSY	NTS
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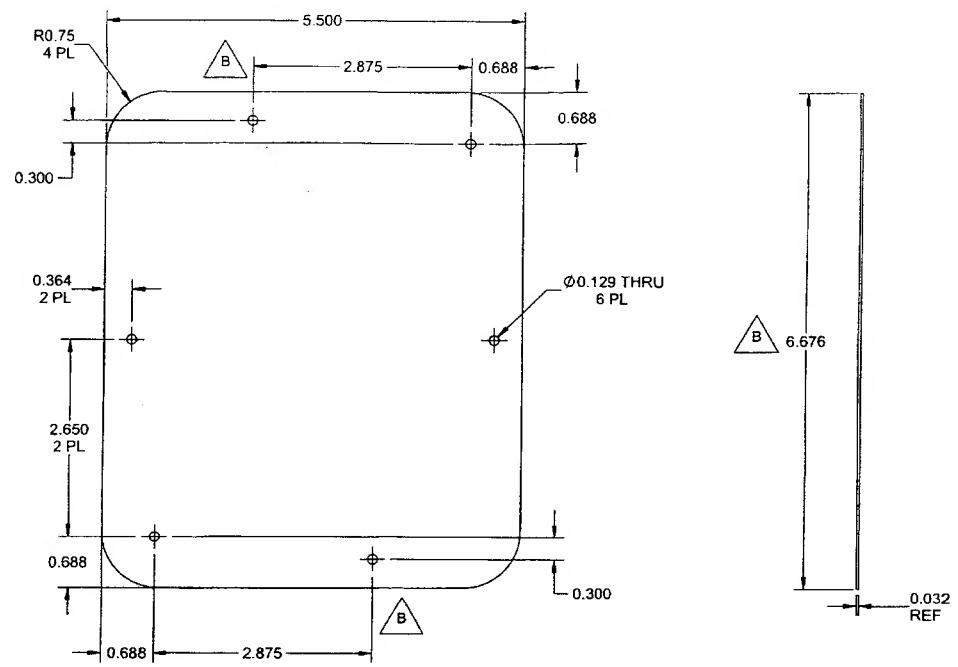
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D3307-1F PANEL (FLAT PATTERN)

RELEASED
2012-05-07

- NOTES:
- 1) MATERIAL: AISI 304/316 SS, ANNEALED, 2B FINISH, 0.032 THICK
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240
OR ASME SA240. (REF. M304S22GA)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.33 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	A.P.	DRAWING NO. D3307	REV. B
MFG. APPR.			SHEET 3 OF 4
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DE APPR.		ACCESS PANEL ASSY	NTS
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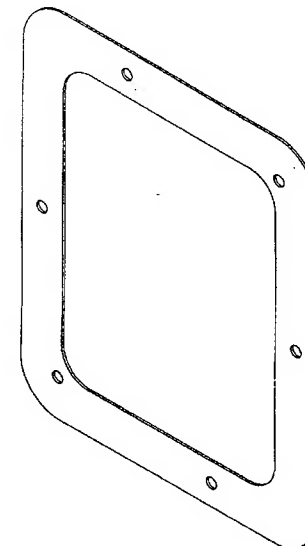
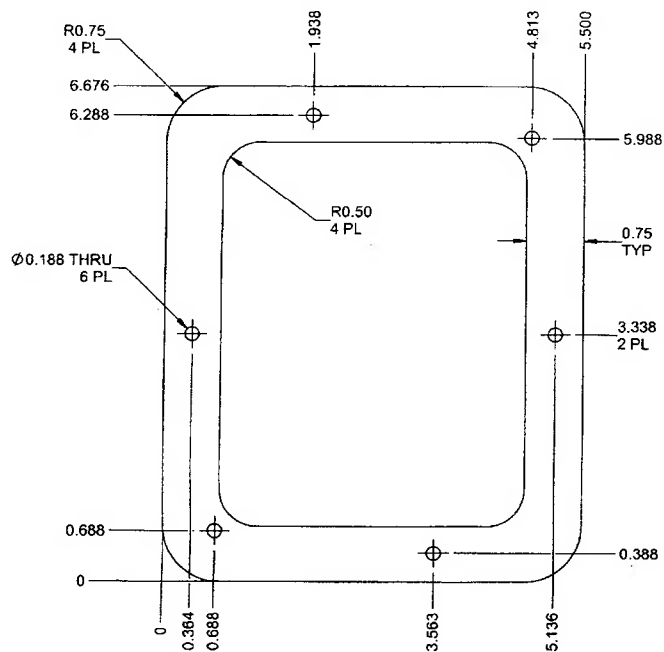
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D3307-3 GASKET

NOTES:

- 1) MATERIAL: DURABLE BLACK GASKET SHEET, 0.035" THICK PER MIL-A-7021C OR MIL-G-12803A OR AMS 3232 OR MIL-A-17472B (REF. DART SPEC. MDURAS.035)
- 2) FINISH: N/A
- 3) TOLERANCES: ALL DIMENSIONS FOR D3307-3 ARE +/- 0.02 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	ED	D3307	SHEET 4 OF 4
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